

6061-T6 1.25" X 4.500"

Work Order ID 81946

81946

Page 1

March-21-12 10:16:11 AM

Item ID: D4101-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step

Start Date: 21/03/2012 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 04/04/2012 Req'd Qty: 6.00 *6* Customer:

Reference:

Approvals: Process Plan: MLS Date: 12/03/21 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4101	B

100	Cut blanks as per folio	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	3.85" LONG								

25 12-03-28

110		0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Mill as per dwg and Folio FA946								
	DEBURR								

6 0 12/03/29

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

6 0 12/03/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Quality Control

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Page 3

March-21-12 10:16:11 AM

Item ID: D4101-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step

Start Date: 21/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location *SP 125* 0.00

160

Packaging

Memo

0.00

Packaging

(60) SP 12-03-30

170

QC21- Final Inspection - Work Order Release 0.00

170

QC

Memo

0.00

Quality Control

12/4/2

R120330

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Picklist Print

March-21-12 10:16:15 AM

Page 1

Work Order ID: 81946

81946

Parent Item: D4101-3

D4101-3

Parent Item Name: Step

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: EST REV:A NEW ISSUE

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X04.50 0		Purchased	No			100	f	6.2417	0.33	2.084211			

M6061T6B1 250X04 500

6061-T6 Bar 1.25 X 4.50

**

12-03-28

Location

Loc Qty

Loc Code

MAT004

6.2417

112628

0.7417

119230

5.5

X2.084211

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DART AEROSPACE LTD		Work Order:	81946
Description: Step		Part Number:	D4101-3
Inspection Dwg: D4101	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.030 deep	+/-0.010	.030	✓		SLO8	VerN
R0.06	+/-0.030	R.060	✓		Rad gauge	
0.25	+/-0.030	.252	✓		SLO8	VerN
4.00	+/-0.030	4.001	✓			
2.60	+/-0.030	2.600	✓			
1.05	+/-0.030	1.050	✓			
1.53	+/-0.030	1.521	✓			
0.950	+0.05/-0.040	.959	✓			
0.25	+/-0.030	.2585	✓			
0.25	+/-0.030	.250	✓			
0.07 x 45°	+/-0.030 x 0.5°	.070x45°	✓			
Ø0.257	+0.006/-0.001	Ø.2585	✓			
0.300	+0.01/-0.010	.292	✓			
R0.06	+/-0.030	R.060	✓		Rad gauge	
0.60	+/-0.030	.597	✓		SLO8	VerN
0.270	+0.01/-0.010	.258	✓			
0.610	+/-0.010	.608	✓			
0.65	+/-0.030	.651	✓			
0.17	+/-0.030	.171	✓			
0.25	+/-0.030	.252	✓			
0.13 x 45°	+/-0.030 x 0.5°	.130x45°	✓			
9°	+/-0.5°	9°	✓			
0.75	+/-0.030	.748	✓			
0.10	+/-0.030	.1055	✓			
0.86	+/-0.030	.8605	✓			
R0.25	+/-0.030	R.250	✓		Rad gauge	
0.13	+/-0.030	.133	✓		SLO8	VerN
2.35	+/-0.030	2.340	✓			
1.15	+/-0.030	1.140	✓			

Measured by:	SL	Audited by:	B.A.	Preliminary Approval:	
Date:	12/03/29	Date:	12/03/29	Date:	

Rev	Date	Change	Revised by	Approved
A	11.10.13	New Issue	KJ	

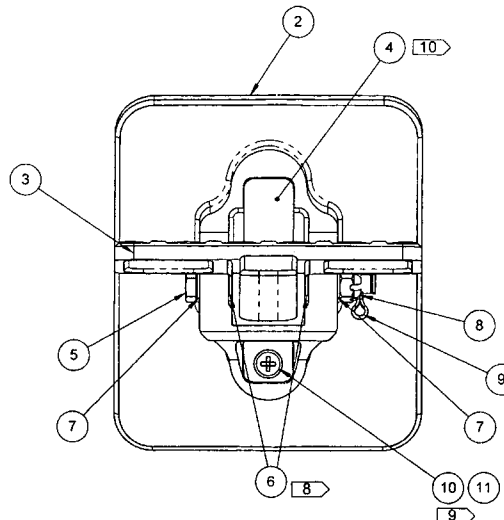
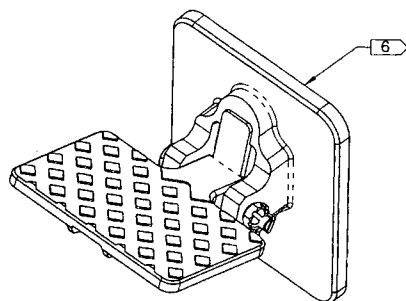
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D4101-041 PRE-FLIGHT STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4101-041" USING FINE POINT PERMANENT INK MARKER BACK SURFACE
- 7) WEIGHT: 1.18 lbs
- 8) INSTALL NAS1149D0432J WASHER IN BETWEEN STEP AND BRACKET MATING FACES
- 9) TORQUE AN525832R SCREW TO 15-25 in-lb
- 10) TEXTURED SIDE TO BOTTOM

ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D4101-041	PRE-FLIGHT STEP ASSEMBLY
2	1	D4101-1	BRACKET
3	1	D4101-3	STEP
4	1	D4101-5	SPRING
5	1	AN4-22	BOLT
6	2	NAS1149D0432J	WASHER
7	2	NAS1149D0463J	WASHER
8	1	AN310-4	NUT
9	1	MS24665-136	COTTER PIN
10	1	AN525-832R6	SCREW
11	1	MS21209C0815	HELICOIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 81946 MCL

12/03/21

RELEASED
2010-08-23

B	NAS1149D0432J WAS NAS1149D0416J (ZN D3-1); ADD SCREW AND HELICOIL (ZN D3-1& B1-3); RE-DESIGN D4101-5 (ZN B4-5)	RF	10.08.05
A	NEW ISSUE	RF	10.07.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4101	SHEET 1 OF 5
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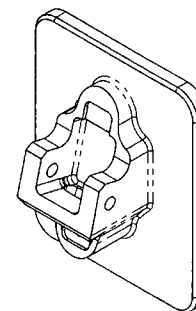
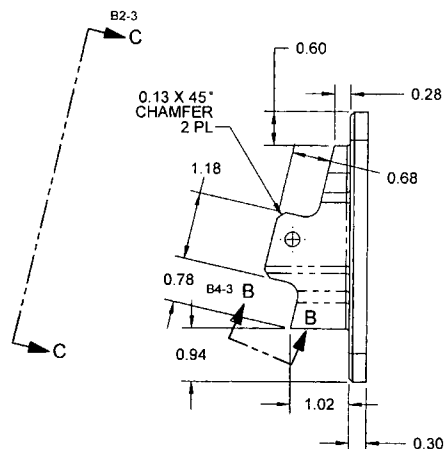
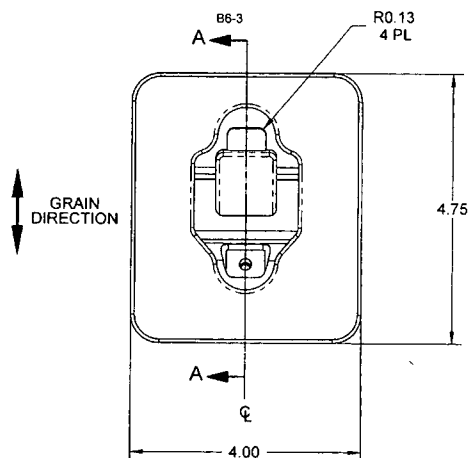
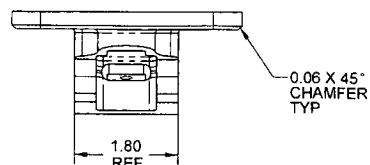
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D4101-1 BRACKET

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2010-08-23

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.85 lbs

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MFG. APPR.	RF	D4101	SHEET 2 OF 5
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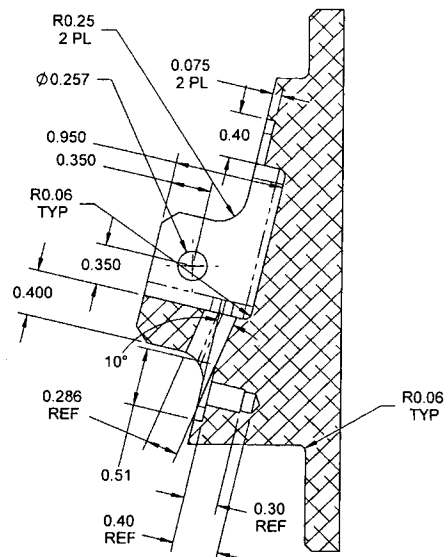
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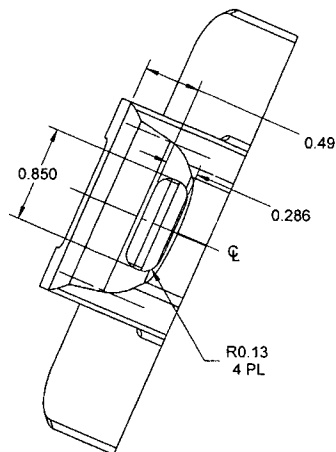
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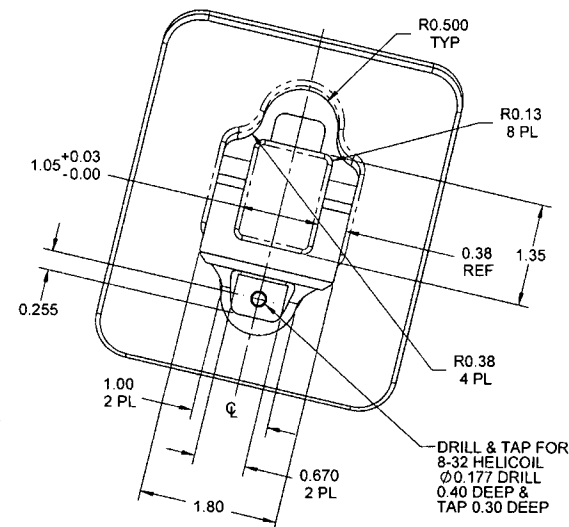
81946



SECTION A-A C7-2
SCALE 2X



VIEW B-B C4-2
SCALE 2X



VIEW C-C D4-2
SCALE X1.5

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MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 5	
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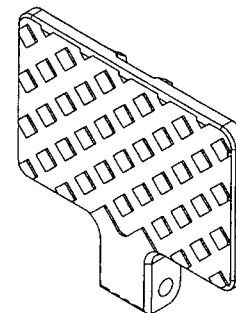
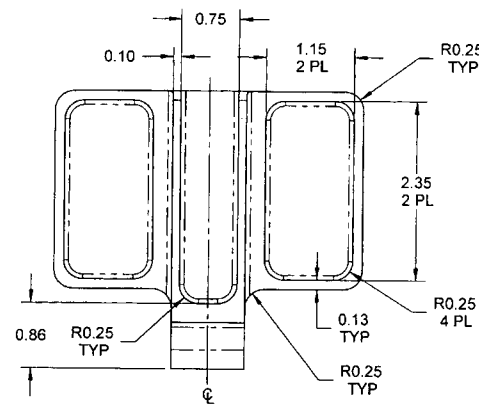
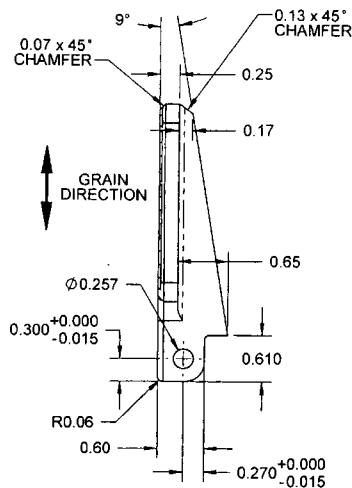
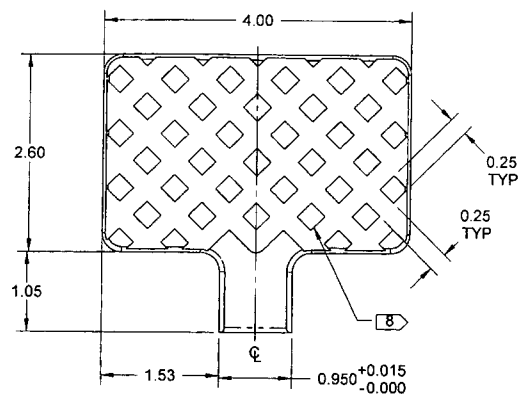
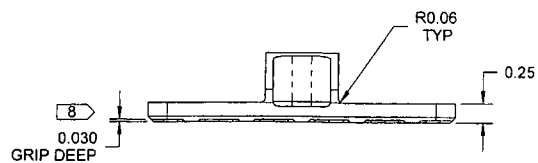
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D4101-3 STEP

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2010-08-23

NOTES:

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PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs
- 8) MACHINE 0.25 x 0.25 GRIP 0.030 DEEP AT 45° PATTERN 0.25 APART

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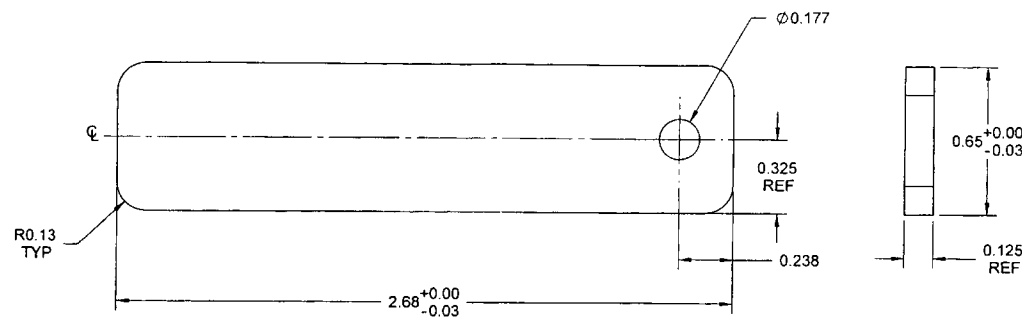
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D4101-5 SPRING



NOTES:

- 1) MATERIAL: F60029-GY3778 DARK GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

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